



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

| S.No. | Check Parameter | Specification | Observations | Remarks |
|-------|---------------------------------------|------------------------|---|---------------------------------------|
| 1 | Work Order No. | | 13003 | 37/50 |
| 2 | Machined By | | V. T. L. n/c Shop | Dy. N. 1802 998 |
| 3 | Pallet Die No. | | 13109 (3.5) n/c | Rev. 01 |
| 4 | Die Category | Drg. No. | Outside | |
| 5 | Out Side Diameter | Drg. No. | 620 n/c Step 00. Tapper. 12° Step length 18.5 | |
| 6 | Inside Diameter | Drg. No. | 520.12 n/c | |
| 7 | Width of Pellet Die | Drg. No. | 222 n/c | |
| 8 | Grooves as per Drawing | Drg. No. | 13x8x5 n/c / 13x8x5 n/c | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | n/c Shop | Tapping N. of holes = 12 Both Side |
| 12 | Tapping PCD | | 565 n/c | |
| 13 | Tapping Hole Diameter | | H202 Check by H20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth. 20.4 n/c Tapping Depth. 18.0 | |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 4/11/24

| | | | |
|---|--------------------------------|--------|---------------------|
| 1 | As per programme no. | | |
| 2 | Gun Drilling Work Completed On | | |
| 3 | Hole Finish In Gun Drilling | Marked | ok |
| 4 | Defective Holes (If Any) | | No. = 1 Hole Closed |

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 80
Rev. 35

| | | | | | | | |
|---|--|---------|---------------|--------|----|--|--|
| 1 | Counter Sinking Depth & Finish | ok | | | | | |
| 2 | External Relief Dia | 4.0 n/c | outside (3-3) | inner | | | |
| 3 | External Relief Depth | | 17 n/c | 13 n/c | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Roxace | | | | |
| 6 | Material Sent For Hardening On Date | | 4 | 11 | 24 | | |

Inspected By (Sign) & Date

Ravi 4/11/24

Sony 4/11/24

Reviewed by (Engineer-CNC)

Manager-QA